

Work Order ID 100484

100484

Page 1

April-22-13 1:41:28 PM

Item ID: D3913-7

Revision ID:

Item Name: Rib

Start Date: 5/03/13 **Start Qty:** 6.00

Required Date: 5/06/13 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: M1.5

Date: 13-04-25 Tooling: Date:

Setup Start *NSC1*

Stop *NS2*

N900040100

* 8x *

Cust Item ID:

Customer:

Process Plan: ML5

Date: 13-04-25 Tooling:

Date:

Run Start *ND1*

Stop  IMPACT

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>				
Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>								
Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>								
Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>								
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Part Moved <input type="checkbox"/>									
Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>									
Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>								
Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>										
Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>										
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>										
Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>										

Work Order ID 100484

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Item ID: D3913-7

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib

Start Date: 5/03/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/06/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/5/30/13

MF

13-5-2013

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION			AGAINST DEPARTMENT/PROCESS								
Part No. _____		Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>		
NCR No. _____		Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>		
		Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>		
		Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General									
				<input type="checkbox"/> Bend		<input type="checkbox"/> Ovalized						<input type="checkbox"/> Pressure/Forced	
				<input type="checkbox"/> BOM/Route		<input type="checkbox"/> Over/Under tolerance						<input type="checkbox"/> Temperature/Cure	
				<input type="checkbox"/> Broken/Damaged		<input type="checkbox"/> Part Incorrect						<input type="checkbox"/> Weld	
				<input type="checkbox"/> Burrs		<input type="checkbox"/> Part Lost/Missing						<input type="checkbox"/> Wrong Stock Pulled	
				<input type="checkbox"/> Contamination		<input type="checkbox"/> Part Moved						<input type="checkbox"/> Other	
				<input type="checkbox"/> Countersink		<input type="checkbox"/> Positioned Wrong						<input type="checkbox"/> Other	
				<input type="checkbox"/> Cut Too Short		<input type="checkbox"/> Power Loss/Surge						<input type="checkbox"/> Other	
				<input type="checkbox"/> Drill Holes		<input type="checkbox"/> Other						<input type="checkbox"/> Other	
				<input type="checkbox"/> Drawing		<input type="checkbox"/> Other						<input type="checkbox"/> Other	
				<input type="checkbox"/> Finish		<input type="checkbox"/> Other						<input type="checkbox"/> Other	
				<input type="checkbox"/> Folio		<input type="checkbox"/> Other						<input type="checkbox"/> Other	
				<input type="checkbox"/> Grain		<input type="checkbox"/> Other						<input type="checkbox"/> Other	
				<input type="checkbox"/> Hardware		<input type="checkbox"/> Other						<input type="checkbox"/> Other	
				<input type="checkbox"/> Inspection Incomplete		<input type="checkbox"/> Other						<input type="checkbox"/> Other	
<input type="checkbox"/> Instructions Incomplete/Unclear		<input type="checkbox"/> Other						<input type="checkbox"/> Other					
<input type="checkbox"/> Maintenance		<input type="checkbox"/> Other						<input type="checkbox"/> Other					
<input type="checkbox"/> Mislabeled		<input type="checkbox"/> Other						<input type="checkbox"/> Other					
<input type="checkbox"/> Misread		<input type="checkbox"/> Other						<input type="checkbox"/> Other					
<input type="checkbox"/> Offset		<input type="checkbox"/> Other						<input type="checkbox"/> Other					
<input type="checkbox"/> Out of Calibration		<input type="checkbox"/> Other						<input type="checkbox"/> Other					
<input type="checkbox"/> Out of Sequence		<input type="checkbox"/> Other						<input type="checkbox"/> Other					
<input type="checkbox"/> Outside Dimensions		<input type="checkbox"/> Other						<input type="checkbox"/> Other					

Picklist Print

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Page 1

Work Order ID: 100484

Parent Item: D3913-7

Parent Item Name: Rib

Start Date: 5/03/13

Required Date: 5/06/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
DD verf:EC

IPP Rev:B 11.01.17 chg qc5 to 6

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	1,065.9843	1.594	10.067368			CC13-5-29

Location	Loc Qty	Loc Code
WA006	1065.984331	B125502
118460	0.00001534	
122938	224.3	
123565	198.684316	
125062	643	

~~XX~~

~~13.423~~ 13.423

NCR: Yes / No

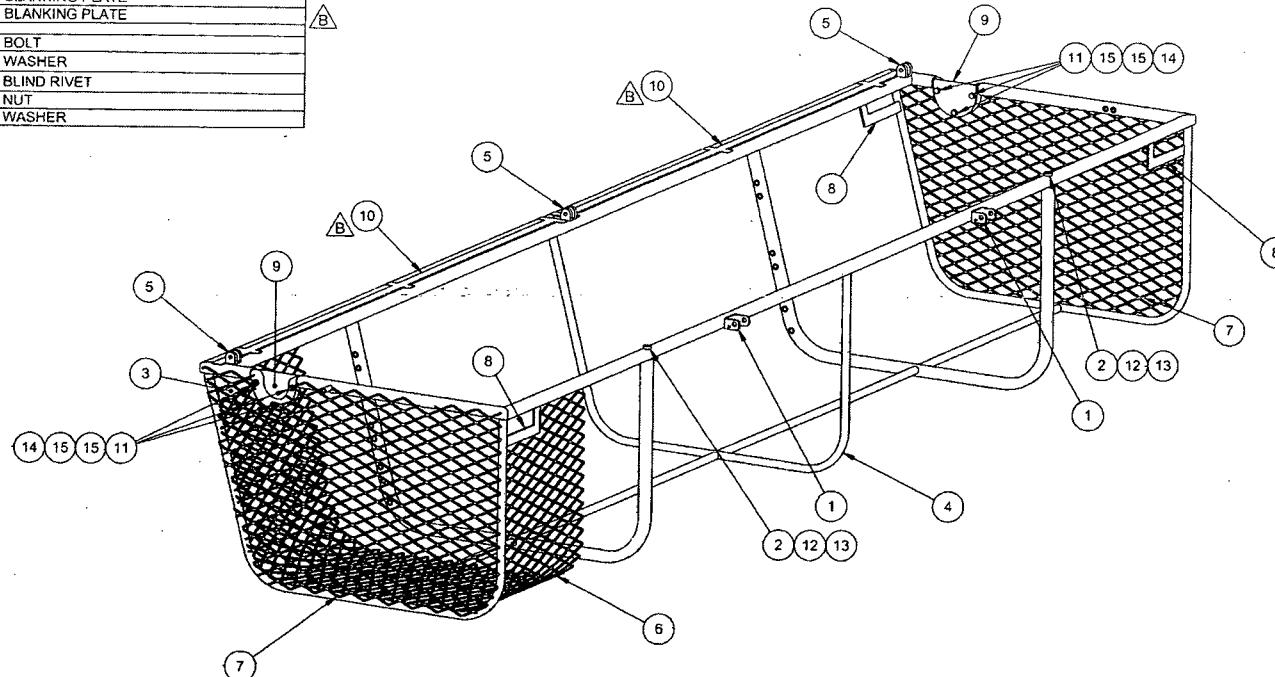
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS																
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>														
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>														
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>														
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>															
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector											
Doc/Data																					
Equip/Tooling																					
Operator																					
Material																					
Setup																					
Other																					
Process																					
Supplier																					
Training																					
Unapproved																					
FAULT CATEGORY																					
Landing Gear				General																	
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio							<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled		<input type="checkbox"/> Other	

ITEM	QTY	P/N	DESCRIPTION
	-041		
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	BLIND RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



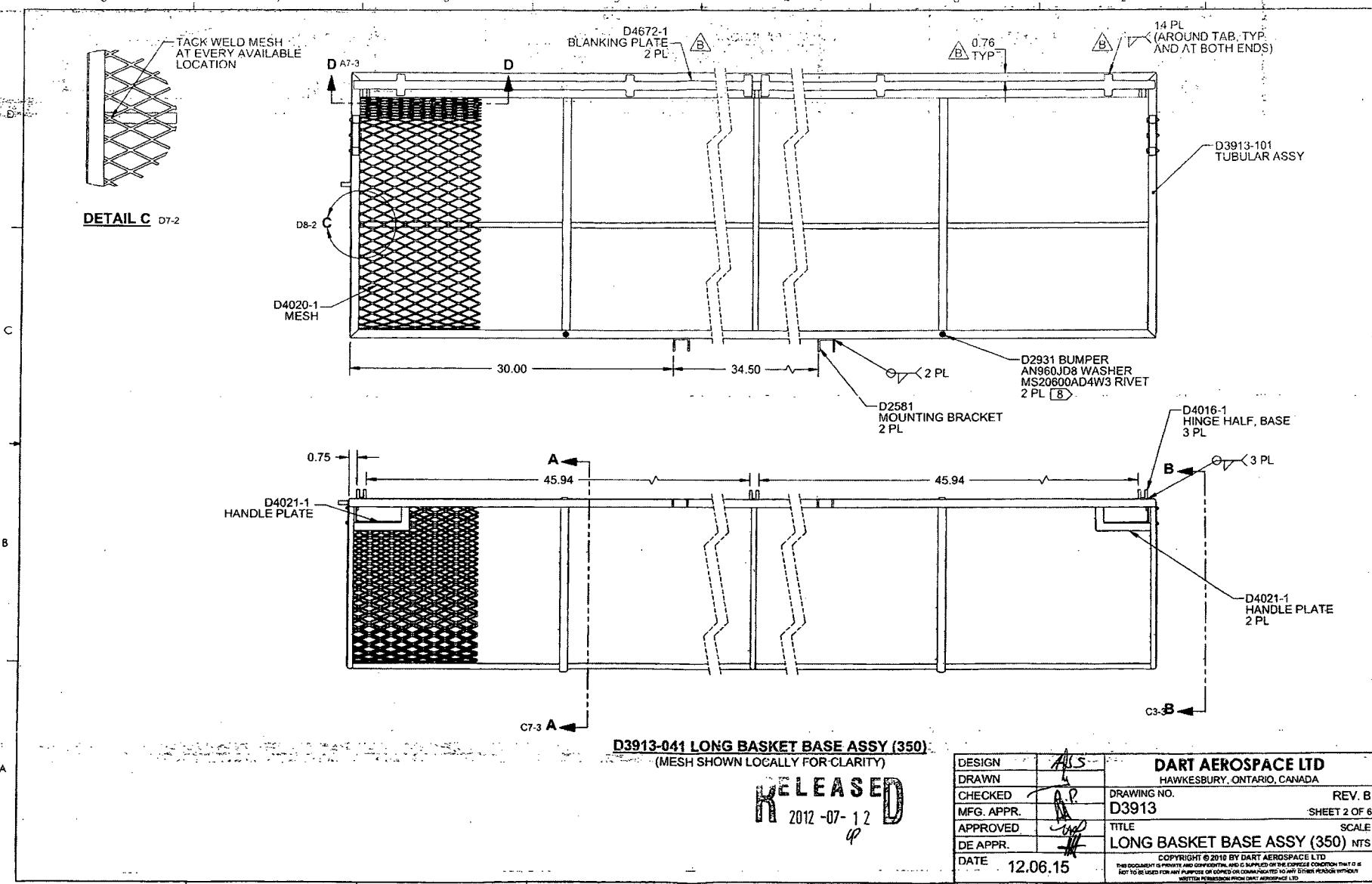
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2)
3) TOLERANCES: PER DART QSI 018 UNL
4) UNITS: INCHES UNLESS OTHERWISE NO
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 43.9 lbs APPROX
8) INSTALL AFTER FINISH
9) MASK HOLES PRIOR TO POWDER COAT
10) WELD PER DART QSI 004

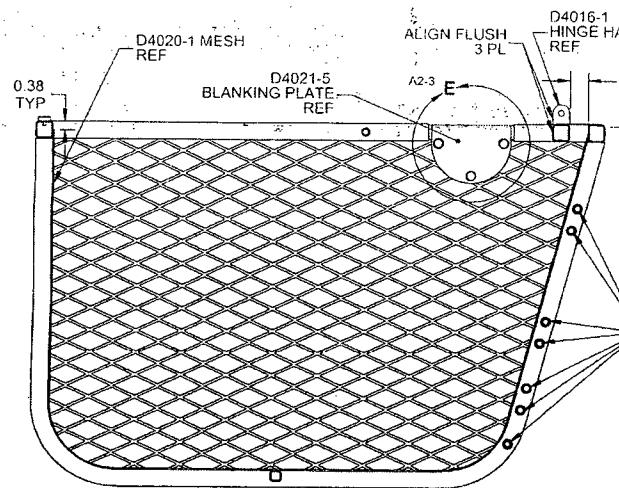
RELEASED
2012-07-12
(P) ECR 12-54

B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-197.			MB	12.06.15
A	NEW ISSUE			JPH	10.03.16
REV.		DESCRIPTION		BY	DATE
DESIGN	<i>A/S</i>	DART AEROSPACE LTD			
DRAWN	<i>A/S</i>	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. B		
MFG. APPR.	<i>A.P.</i>	D3913	SHEET 1 OF 6		
APPROVED	<i>L.A.P.</i>	TITLE	SCALE		
DE APPR.	<i>L.A.P.</i>	LONG BASKET BASE ASSY (350) NTS			
DATE	12.06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD			
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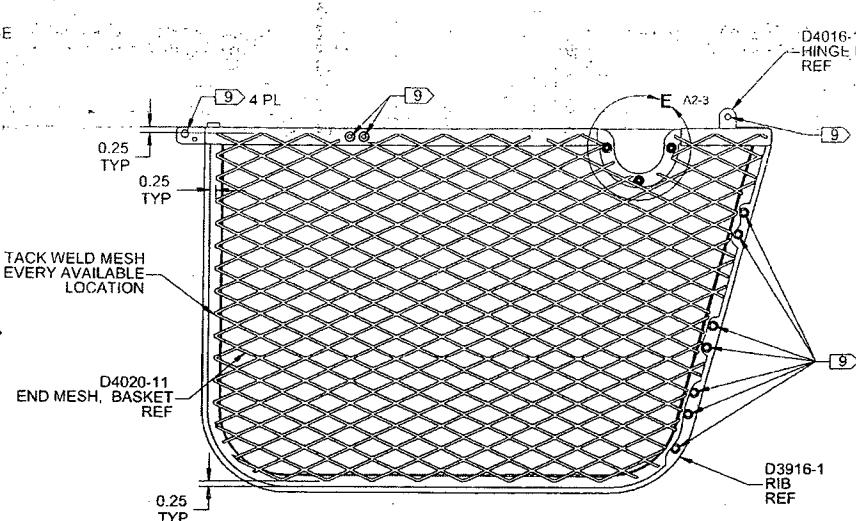
100484



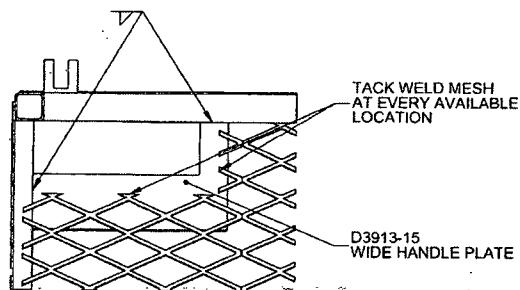
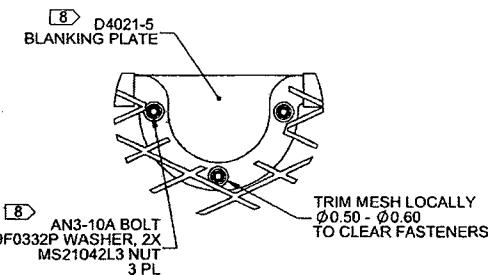
160484



SECTION A-A A5-2



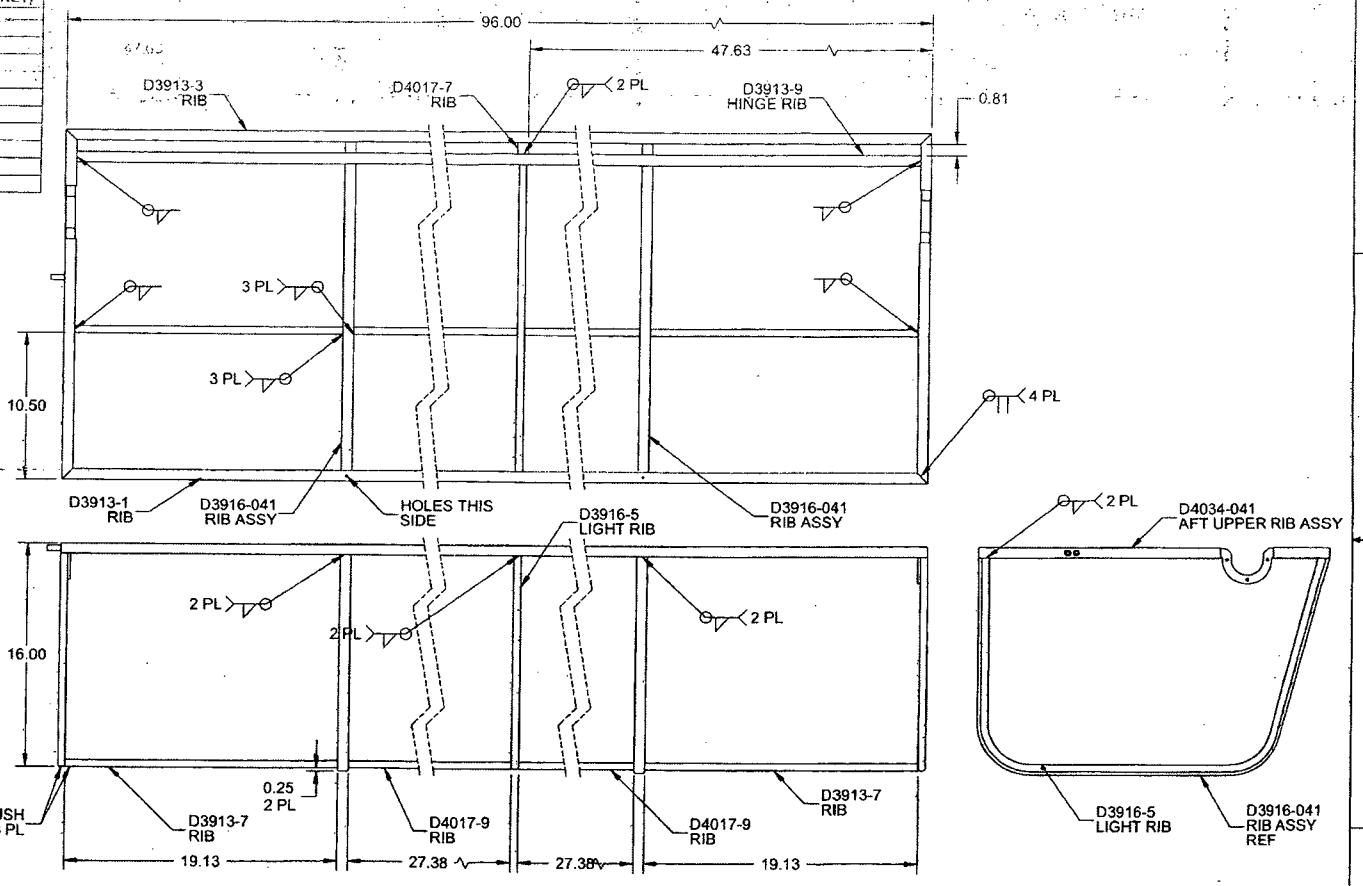
VIEW B-B A2-2

SECTION D-D D6-2
TYPICAL FOR ALL
HANDLE PLATESRELEASED
2012-07-12
IP

DESIGN *AS*
DRAWN *Q*
CHECKED *Q*
MFG. APPR. *Q*
APPROVED *Q*
DE APPR. *Q*
DATE 12.06.15

DART AEROSPACE LTD
HAWKSLEY, ONTARIO, CANADA
DRAWING NO. D3913
REV. B
SHEET 3 OF 6
TITLE SCALE
LONG BASKET BASE ASSY (350) NTS
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ITEM	QTY	P/N	DESCRIPTION
	-101		TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



B) D3913-101 TUBULAR ASSY (350 SHORT BASKET)

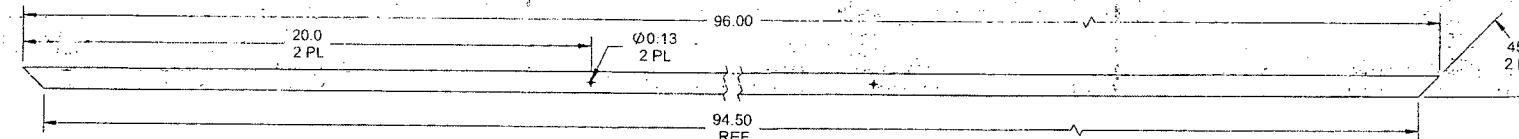
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

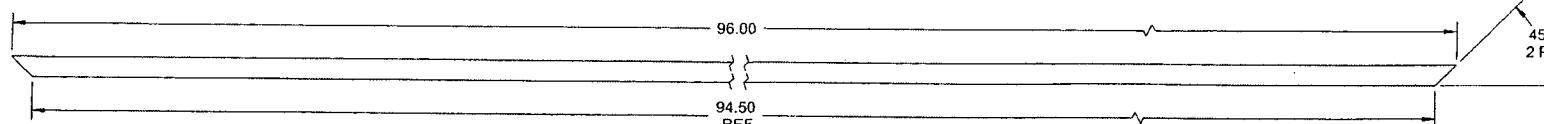
RELEASED
2012-07-12
9

DESIGN	AS
DRAWN	
CHECKED	AP
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	12.06.15

DART AEROSPACE LTD
HAWKSLEY, ONTARIO, CANADA
DRAWING NO. D3913 REV. B
SHEET 4 OF 6
TITLE LONG BASKET BASE ASSY (350) NTS
SCALE
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WRITTEN INFORMATION FROM DART AEROSPACE LTD



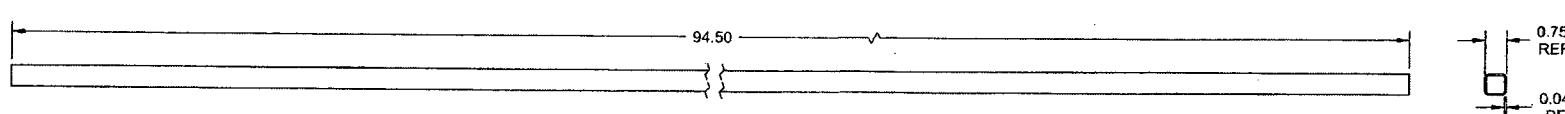
D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049

7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED

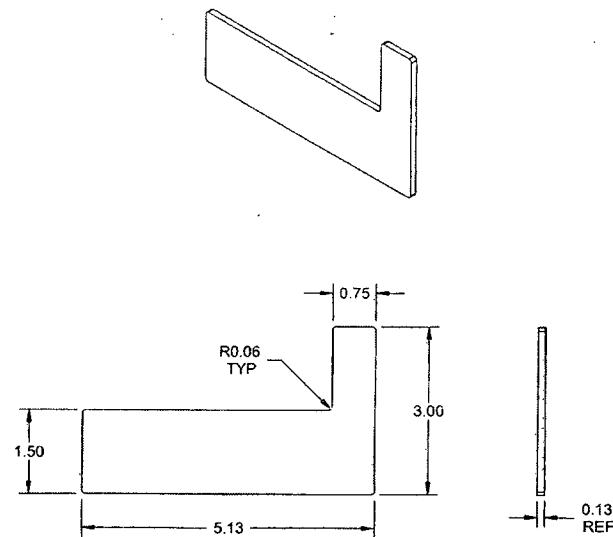
2012-07-12

IP

DESIGN	ALS	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. B
MPC. APPR.		D3913
APPROVED		SHEET 5 OF 6
DE APPR.		TITLE
DATE	12.06.15	SCALE
		LONG BASKET BASE ASSY (350) NTS

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100484

D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2012-07-12

DESIGN	415	DART AEROSPACE LTD
DRAWN	5	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.0.	DRAWING NO. D3913
MFG. APPR.	M	REV. B
APPROVED	S	SHEET 6 OF 6
DE APPR.	W	TITLE
DATE	12.06.15	SCALE
		LONG BASKET BASE ASSY (350) NTS

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